

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018048**Date Inspected:** 10-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Larry Viars was present during the times noted above for observations relative to the work being performed.

Bay 16-

This QA Inspector observed the following work in progress: Flux Cored Arc Welding (FCAW) of OBG Segment 13AW bottom panel stiffener weld, BP3056-002-039 and 040. ZPMC welder was identified as 070254 and 037705. ZPMC QC was identified as Liu Dao Feng. ZPMC CWI was identified as Xu Tao. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2132.

Flux Cored Arc Welding (FCAW) of OBG Segment 13AW bottom panel stiffener weld, BP3056-002-057 and 058.

ZPMC welder was identified as 020009 and 066421. ZPMC QC was identified as Liu Dao Feng. ZPMC CWI was identified as Xu Tao. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2132.

Bay 19-

This QA Inspector observed the following work in progress: Flux Cored Arc Welding (FCAW) of OBG Suspender Bracket 94E weld, SB021-094-004. ZPMC welder was identified as 058792. ABF CWI was identified as Peng Wen Jian. The welding appeared to be in conformance with ZPMC Welding Repair Report B-WR 15832 and welding procedure specification, WPS-345-FCAW-2G(2F)-Repair.

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This QA Inspector performed Magnetic Particle Testing (MT) verification of welds previously tested and accepted by ZPMC for OBG Bike Path welds. See MT report TL-6028 generated this date for additional information. The following welds was tested:

BK004A-001-014, 015, 110, 024, 025, 123, 124, 034, 035, 113, 114

BK004A5-001-074, 075, 119, 120, 084, 085, 132, 133

BK004ASD1-003-005, 006, 018, 021

Blast Bay 1-

Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of OBG segment 11DE upper section base metal and weld surfaces. Areas requiring light grinding were marked for ZPMC personnel. Items which require repair were recorded for future repair.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation between QA and QC occurred this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
